

**DEPARTMENT OF TRANSPORTATION****DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
690 Walnut Ave. St. 150  
Vallejo, CA 94592-1133  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.21**WELDING WITNESS REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WWR-000611**Date Inspected:** 17-Nov-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 1300**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1420**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

**Witness:** **Procedure Qualification Record**  
**Welding** **NDT**

**Welder Qualification** **Fracture Critical**  
**Mechanical Testing, describe:** CVN, Bends, Macros and  
Tensiles

**Index Lot #:****Bridge No:** 34-0006**Welder:****Witness Lot #:** B41-034-08**Component:** PQR**ID #:****Joint Description:**

N/A

**WPS ID #:**

N/A

**Base Metal:** HPS485WT2

N/A

**PQR ID #:**

HP2008105

N/A

**Thickness:** 75mm

N/A

**Process:**

SMAW

N/A

**Electrode Spec/Class:** THJ506Fe-1

N/A

**Positions:**

4G

N/A

**Backing Material:**

N/A

**CWI:**

N/A

**Average Amps:**

N/A

**AWS Code:**

D1.5-2002

N/A

**Average Volts:**

N/A

**Applicable Sec:**

Section 5, figure 5.1

N/A

**Travel Speed:**

N/A

**Heat Input:**

N/A

**Preheat:**

N/A

**Summary of Items Observed:**

The Caltrans Quality Assurance Inspector (QA) was present as requested by the contractor to witness mechanical testing of PQR HP2008105 at the ZPMC metals laboratory located onsite.

The test appeared to comply with the contract documents and a copy of the results were recorded and submitted to the QA.

**Summary of Conversations:**

The American Bridge/ Fluor (ABF) representative, Mr. Craig Knopps stated the results would be forwarded.

is in general conformance with the contract requirements.

**Observed welding, testing or results:**

is not in conformance with the contract requirements.

**Comments**

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Ryan Smith, (858) 232-6799, who represents the Office of Structural Materials for your project.

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## WELDING WITNESS REPORT

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**Inspected By:** Wright,Mark

Quality Assurance Inspector

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**Reviewed By:** McClary,David

QA Reviewer